AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A method of manufacturing a full face vehicle wheel ~~including~~comprising:

providing a wheel rim with one opening brim thereof formed to be a flange portion while the other opening brim to be a peripheral joining end; and

providing a wheel disk with the periphery thereof formed to be a flange portion for supporting a tire bead sidewise, with said peripheral joining end welded to the back surface of said wheel disk~~:, characterized in that:~~

providing the back surface of the wheel disk ~~is provided~~ in advance with an annular joining groove;

providing the peripheral joining end of the wheel rim ~~is provided~~ in advance with an inside slope end surface;

seating and positioning said peripheral joining end ~~is seated and positioned~~ on the bottom surface of the annular joining groove;

~~in which state,~~ producing a welding heat confining annular region ~~is produced~~ between the inside groove wall of the annular joining groove and the inside slope end surface by placing the inside edge of the inside slope end surface in contact with or near said inside groove wall; and

joining the annular joining groove and the peripheral joining end ~~are joined~~ by welding, so that the wheel disk and the wheel rim are joined.

Claim 2 (original): The method of manufacturing the full face vehicle wheel of Claim 1, wherein the inside slope end surface formed at the peripheral joining end of the wheel rim has a slope angle within a range greater than about three degrees and not greater than about 60 degrees relative to the bottom surface of the annular joining groove.

Claim 3 (currently amended): The method of manufacturing full face vehicle wheel of ~~Claim 1 or 2~~Claim 1, ~~wherein~~ further comprising:

forming the inside slope end surface of the peripheral joining end of the wheel rim ~~is formed~~ by bending the opening brim where said peripheral joining end is formed toward the inside of the wheel rim.

Claim 4 (currently amended): The method of manufacturing the full face vehicle wheel of ~~any one of Claims 1 to 3~~ claim 1, ~~wherein~~ further comprising:

forming the outside groove wall of the annular joining groove ~~is formed~~ to tilt outward by an angle within a range greater than about 40 degrees and not greater than about 90 degrees relative to the bottom surface of the annular joining groove.